

Date: Tuesday, 06/02/2007 3:19:27 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP ASSEMBLY (206/407)
Job Number	: 29740A		
Estimate Number	: 11775		
P.O. Number	: <i>NIA</i>	Part Number	: D2842042
This Issue	: 06/02/2007	Drawing Number	: D2842 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 05/12/2006	Drawing Revision	: B
Previous Run	: 26753A	Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 20/01/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	5 Um: Each
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>329607</i>

Check Material for any Dents or Defects

PE. 07.02.02 5

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

3-Deburr and bevel ends for welding

PE. 07.02.02 5

PE. 07.02.02 5

PE 07.02.03 5

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>329340</i>

PE. 07.02.03 5

Date: Tuesday, 06/02/2007 3:19:27 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29740A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation: Description :

4.0 D2776 Step Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Step Lug

Pick:

Qty Part Number Description Batch

2 D2776Lug

5.0 D34593 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-3Lug

$B29795 = 6$ $B25430 = 4$

$SE 07.02.03$ 5

6.0 D34591 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D3459-1 Lug

$B27121 = 6$ $B25429 = 4$

$SE 07.02.03$ 5

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT

as per Dwg D2842

A/R AL Rod Batch: $M100237$

$M102225$

2-Grind end cap weld flush

$SE 07.02.06$ 5

$F.F. 07.02.06 = 4$

$SE 07.02.06$ 4
1

8.0 QC5/9



WELD INSPECTION

$M07/02/08$ 5



Comment: WELD INSPECTION

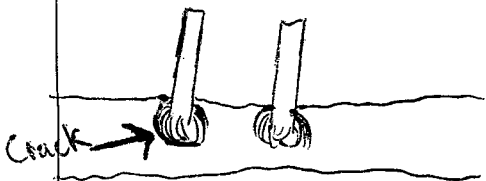
$J 07.02.06$ 5

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2842-042 PAR #: N/A Fault Category: Prod/Rep. ass. 1st NCR: Yes No DQA: D Date: 07/02/08
 QA: N/C Closed: 19 Date: 07.02.19

NCR: <u>29740 A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/02/08</u>	<u>8.0</u>	<u>-2 step</u> <u>when welding lug on step</u> <u>Weld crack</u>	<u>Qs1042</u>	<u>Clean area and reweld</u> <u>-retrain worker on cleaning</u> <u>Step and lug plus preheat</u> <u>area when before welding</u>	<u>07.02.08</u>	<u>07/02/08</u>	<u>Qs1042</u>	<u>07/02/08</u>
								

NOTE: Date & initial all entries

Date: Tuesday, 06/02/2007 3:19:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29740A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation: Description:

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MP14

07-02-08 (5)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/02/08 (5)

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M100237

2-Grind end cap weld flush.

PE-07-02-08

PE-07-02-08

FF 07-02-08 (2) PE 07-02-08 (3) 5

12.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-02-08 (5)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-02-08 (5)

14.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

M103141

FR/

07/02/08 (5)

07-02-08 (5)

15.0 NAS1329C3KB130 insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3 NAS1329C3KB130Insert

M100034

a.m 07/02/12 (3)

Date: Tuesday, 06/02/2007 3:19:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29740A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation: Description :

16.0 MS27039C107 screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 MS27039C1-07 Screw m19522

a.m 07/02/12 (3)

17.0 NAS1515H3L WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 NAS1515H3L WASHER m102724

a.m 07/02/12 (3)

18.0 AN960C10L washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 AN960C10L WASHER m103344

a.m 07/02/12 (3)

19.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: 102098

gl 07/02/13X5

20.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

21.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(+1 HA a)

7/2/04

Date: Tuesday, 06/02/2007 3:19:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29740A

Part Number: D2842042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

29740A

23.0

QC21

FINAL INSPECTION/W/O RELEASE



ATC

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CL07/02/14

Date: Tuesday, 12/5/2006 7:52:58 AM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT STEP ASSEMBLY LH (206/407)
Job Number :	29740A	Part Number :	D2842042
Estimate Number :	11775	Drawing Number :	D2842 REV B
P.O. Number :		Project Number :	N/A
This Issue :	12/5/2006	Drawing Revision :	B
Prsht Rev. :	NC	Material :	
First Issue :	1/1	Due Date :	1/20/2007
Previous Run :	26753A	Qty:	5
Written By :		Um:	Each
Checked & Approved By :	JF 061205		
Comment :	Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B29607

Check Material for any Dents or Defects

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

3-Deburr and bevel ends for welding

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B29340

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/08	N.O	inspection level 3 was not signed off before welding	AS.042	Every inspection level must be signed off before starting the next step if something is wrong the work is done for nothing.	AS 07/02/08	AS 07/02/08	AS.042	AS 07/02/08

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:52:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29740A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D2776

Step Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Lug

Pick:

Qty Part Number Description Batch

2 D2776 Lug

2 D3459-3

2 D3459-1

329795=6

825430=4

827121=6

825429=4

LC. 07.02.03

5

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT

as per Dwg D2842

A/R

AL Rod

Batch:

MIC237
MIC225

2-Grind end cap weld flush

LC. 07.02.06

5

F.F. 07.02.06 = 4 LC. 07.02.06 = 1

14

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R

AL Rod

Batch:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:52:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29740A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Grind end cap weld flush.

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

13.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3 NAS1329C3KB130Insert

14.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 MS27039C1-07

Screw

15.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 NAS1515H3L

WASHER

16.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:52:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29740A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

3 AN960C10L WASHER

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: _____

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

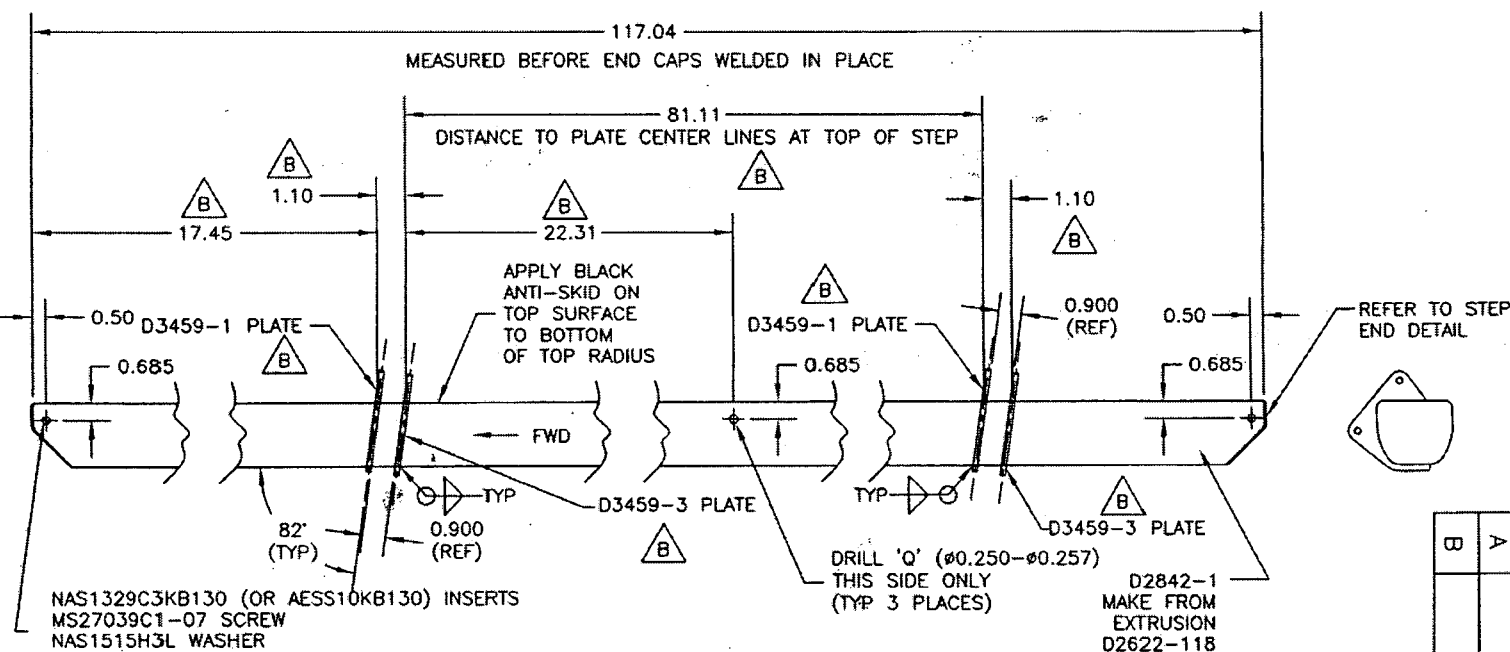
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY
		SCALE NTS
A	98.10.13	NEW ISSUE
B	05.09.23	RE-DESIGN, ADD D3459-1/-3



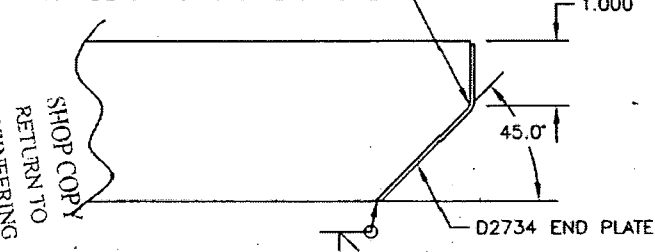
NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05/1/14